

Friday, March 13, 2015 12:57:28 PM

130523

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearplate Center

Stop *NS2*

Start Date: 3/13/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 3/13/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-03-13 Tooling:

Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: 12/10/2019

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4956	A
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100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: **A**

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

13 Ø Imis-3-16

13 Ø Jm15-3-16

Work Order ID 130523

Friday, March 13, 2015 12:57:28 PM

130523

Page 2

Item ID: D4956-21 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(13)			DAS 38 9-89 MAR 17 2015
130 *130* Brake NC Brake NC	Form as per dwg Memo FORM JOGGLE AS DWG	0.00 0.00			DAS 30 9-89		13x		MAR 18 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(13)			DAS 38 9-89 MAR 18 2015

130523

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/13/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 3/13/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

0.00

150

0.00

HandFinish

Memo

Hand Finishing

1- After finish, coat entire top (concave) surface as per note 2 dwg D4956.
TEXTURED COATING B#: 131609

160

QC3- Inspect Part Finish

0.00

160

0.00

OC

Memo

Quality Control

170

Identify as per dwg & Stock Location: 1-007 0.00

0.00

170

0.00

Packaging

Memo

Packaging

Work Order ID 130523

Friday, March 13, 2015 12:57:28 PM

130523

Page 4

Item ID: D4956-21 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 3/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-20

15-3-20

Picklist Print

Friday, March 13, 2015 12:57:31 PM

Page 1

Work Order ID: 130523

130523

Parent Item: D4956-21

D4956-21

Parent Item Name: Wearplate Center

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

sf

343.7123

M304S20GA

**

6
10

Jm15-3-16

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

212.6

m131700

212.6

MAT020

131.1123

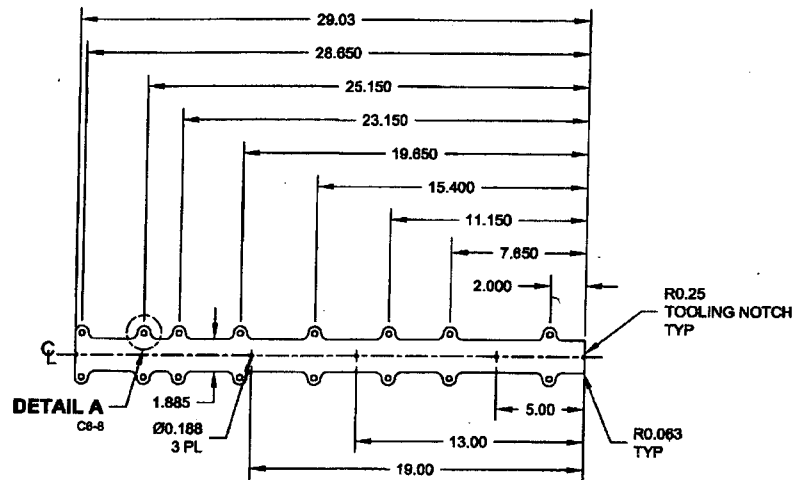
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1.5139

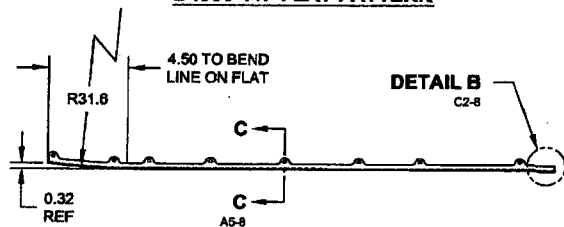
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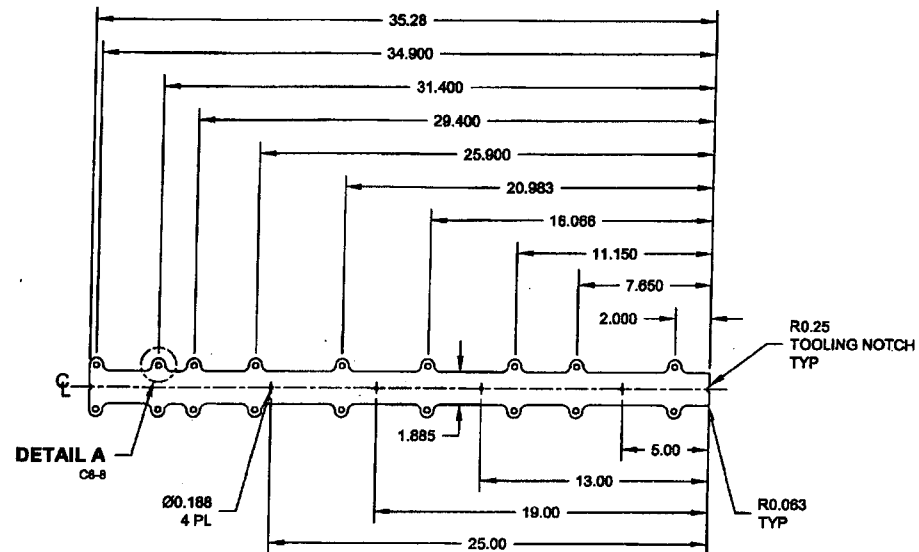
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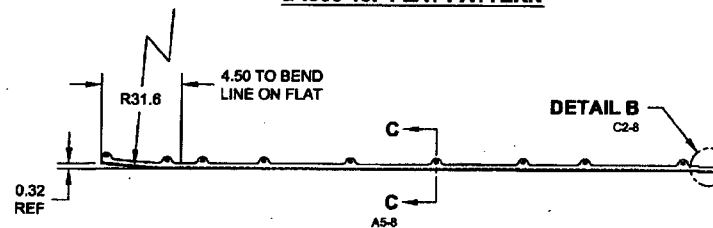
D4956-11F FLAT PATTERN



D4956-11 WEARSHOE
(MAKE FROM D4956-11F)



D4956-13F FLAT PATTERN



D4956-13 WEARSHOE
(MAKE FROM D4956-13F)

NOTES

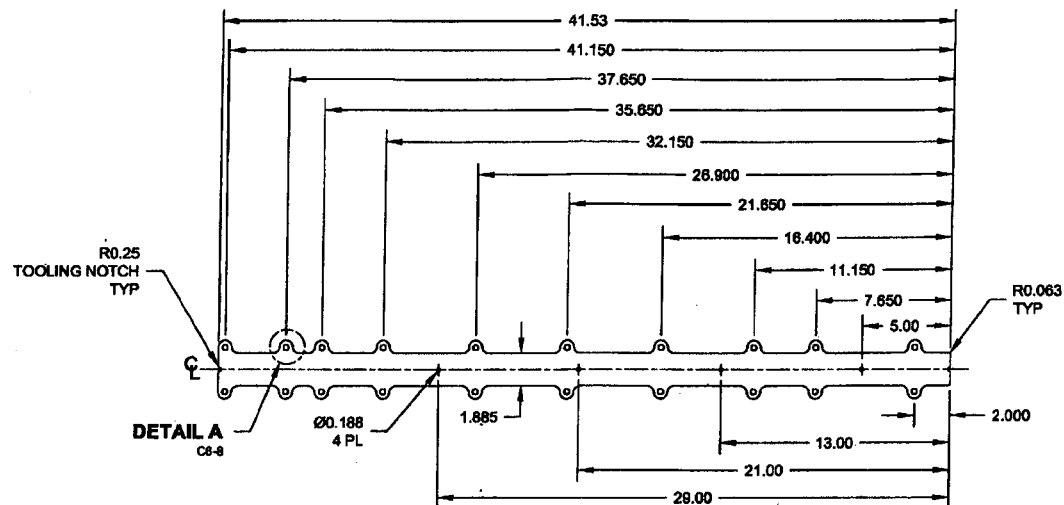
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PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-11 = 0.68 lbs; D4956-13 = 0.82 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

RETURN TO

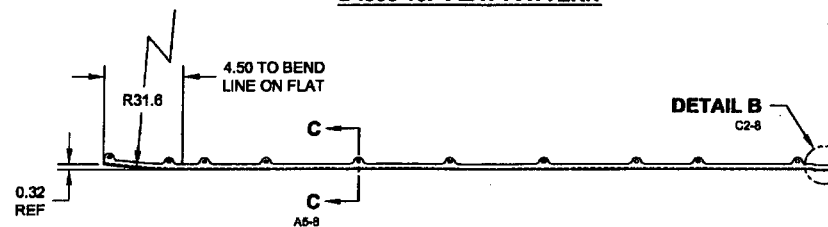
NO. 130523
MLJ
1503-13

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2014-06-17

A	NEW ISSUE	MB	13.09.26
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DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.09.26		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D4956		SHEET 1 OF 8	
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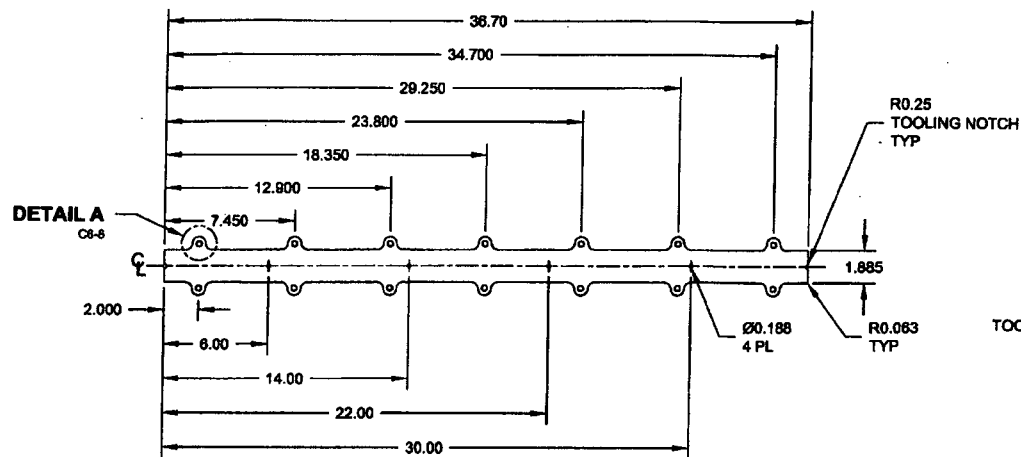
D4956-15 WEARSHOE
(MAKE FROM D4956-15F)

NOTES

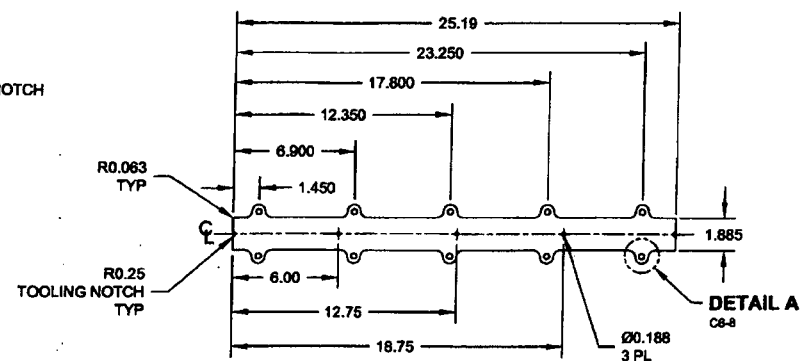
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REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.95 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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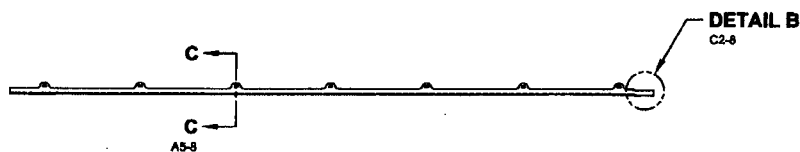
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2014-04-17



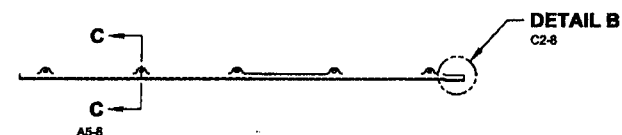
D4956-21F FLAT PATTERN



D4956-25F FLAT PATTERN



D4956-21 WEARSHOE
(MAKE FROM D4956-21F)



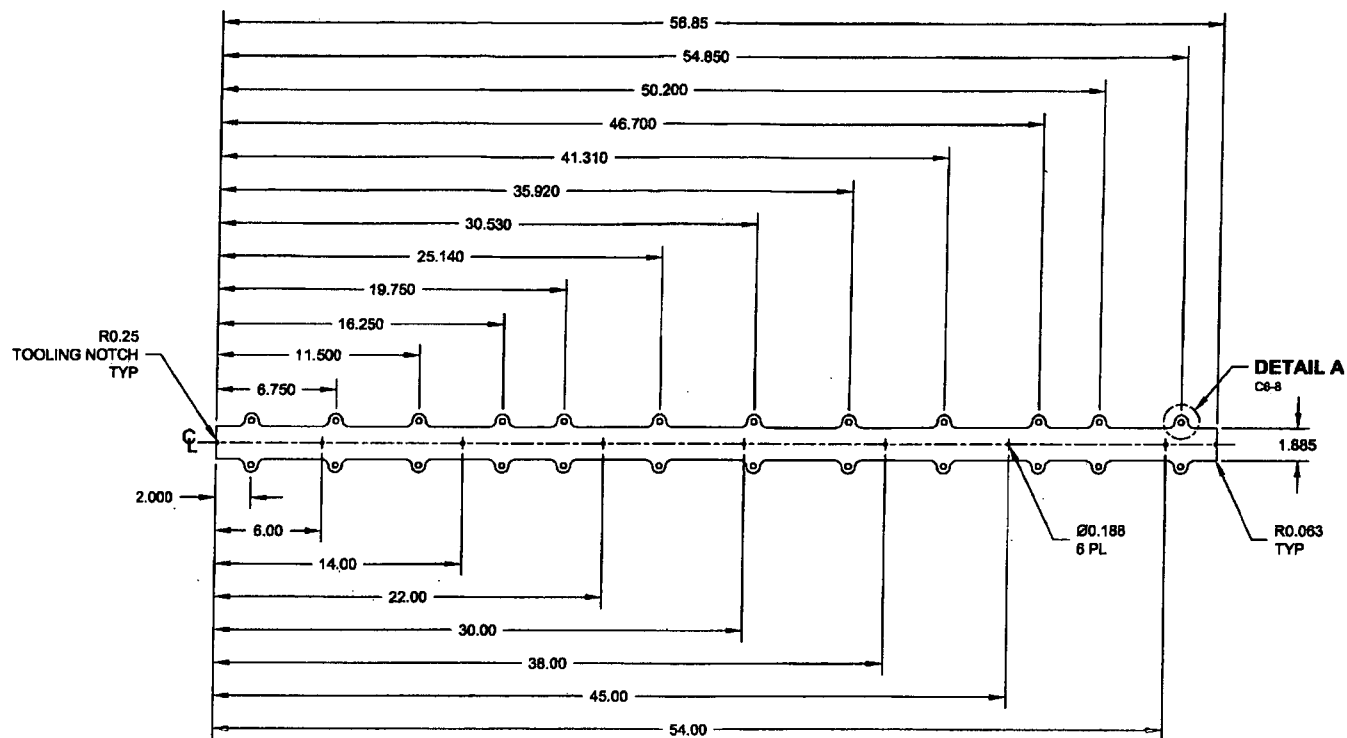
D4956-25 WEARSHOE
(MAKE FROM D4956-25F)

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-21 = 0.82 lbs; D4956-25 = 0.68 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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D4956-23F FLAT PATTERN



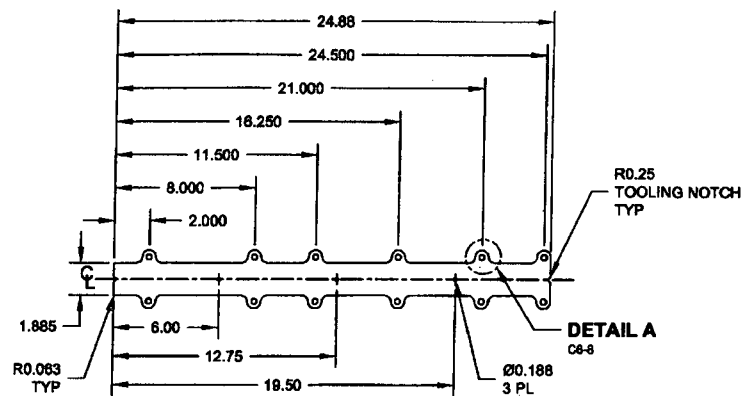
D4956-23 WEARSHOE
(MAKE FROM D4956-23F)

NOTES

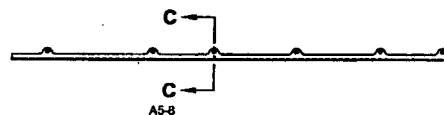
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PER AMS 5613 OR 5524 OR ASTM A240 OR ASME SA240
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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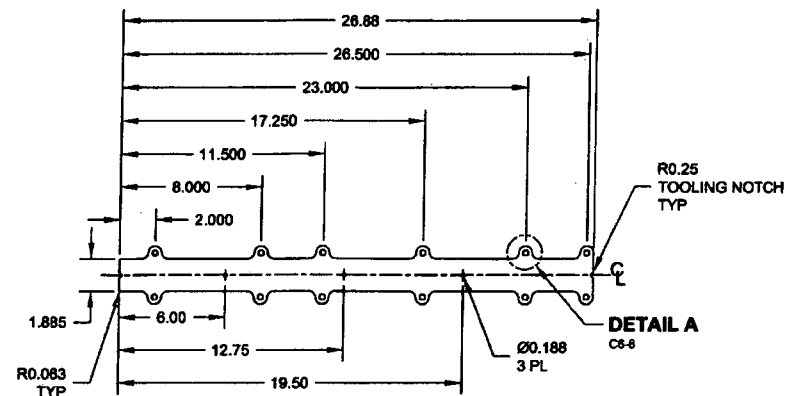
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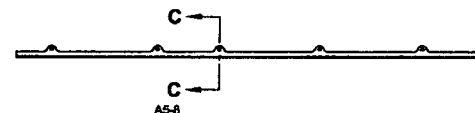
D4956-31F FLAT PATTERN



D4956-31 WEARSHOE
(MAKE FROM D4956-31F)



D4956-33F FLAT PATTERN



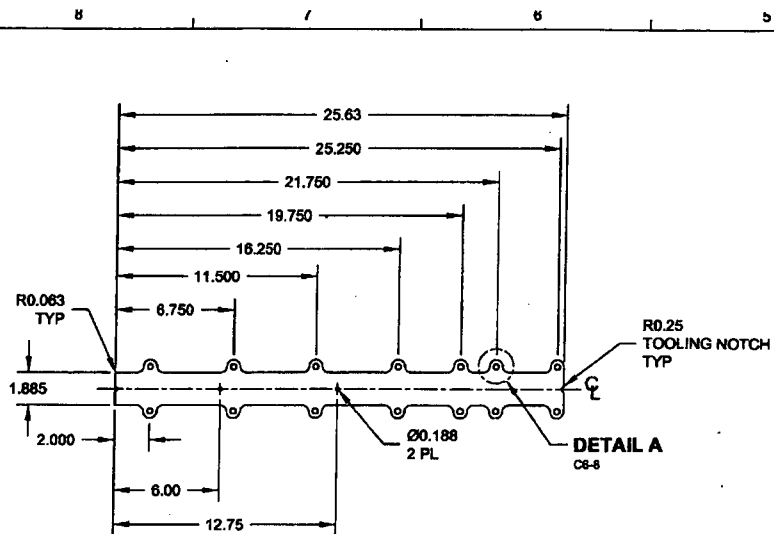
D4956-33 WEARSHOE
(MAKE FROM D4956-33F)

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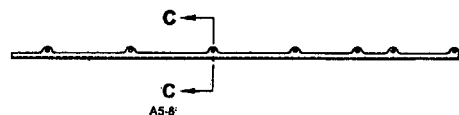
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PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-31 = 0.57 lbs; D4956-33 = 0.61 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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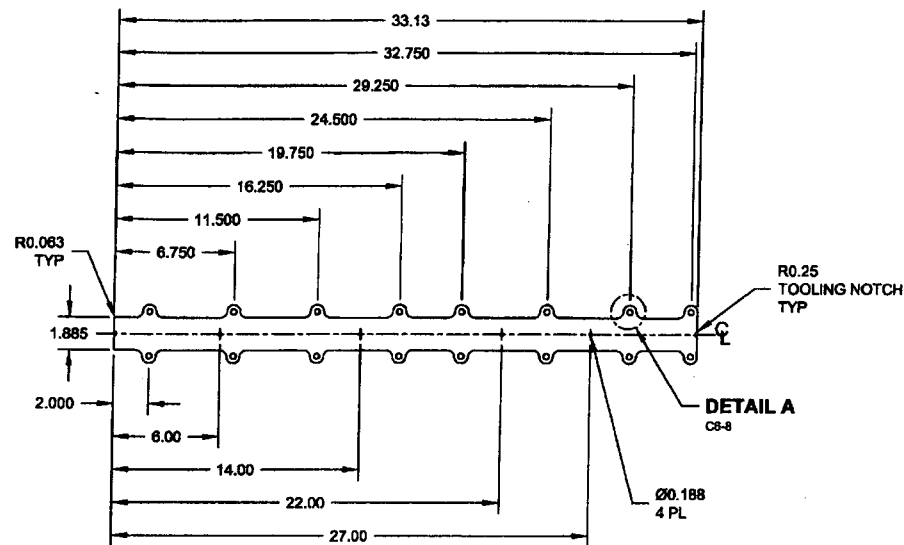
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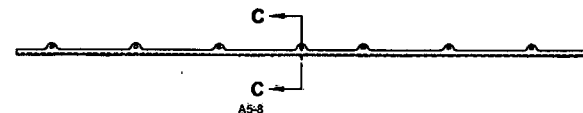
D4956-35F FLAT PATTERN



D4956-35 WEARSHOE
(MAKE FROM D4956-35F)



D4956-37F FLAT PATTERN



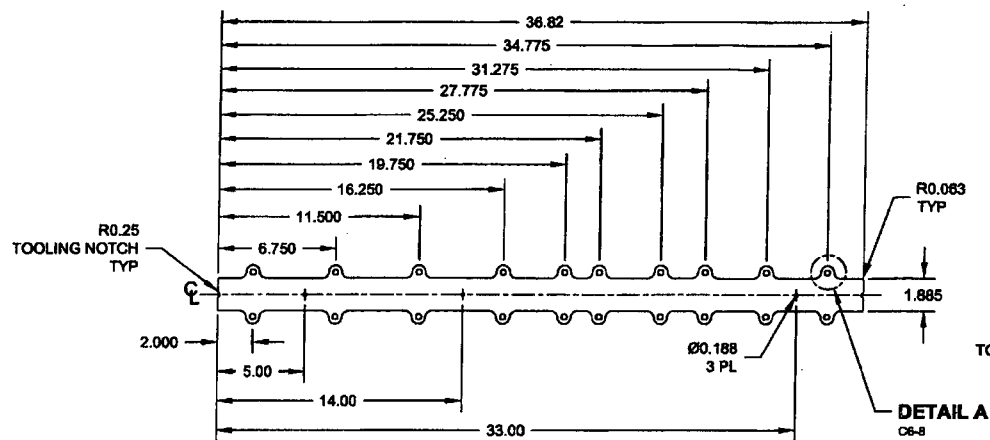
D4956-37 WEARSHOE
(MAKE FROM D4956-37F)

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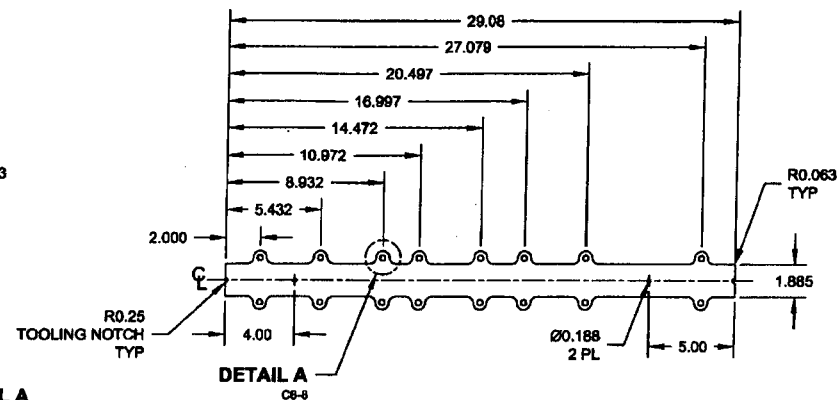
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REF DART SPEC M304S20GA
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-35 = 0.60 lbs; D4956-37 = 0.76 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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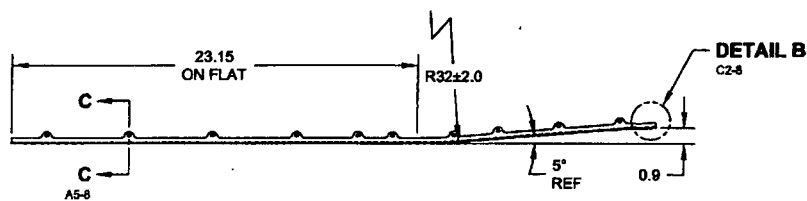
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2014-04-17



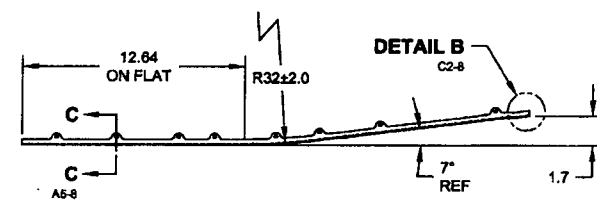
D4956-39F FLAT PATTERN



D4956-41F FLAT PATTERN



D4956-39 WEARSHOE
(MAKE FROM D4956-39F)



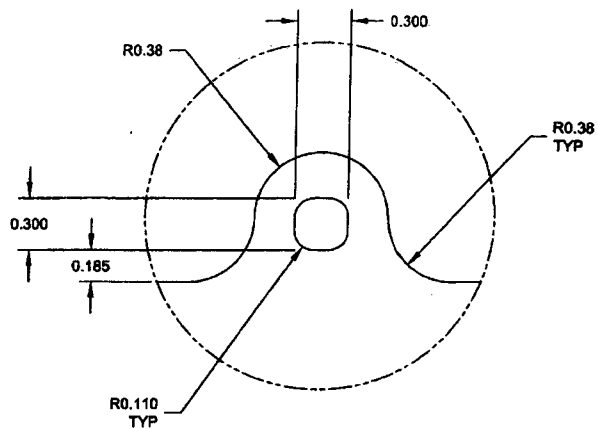
D4956-41 WEARSHOE
(MAKE FROM D4956-41F)

NOTES

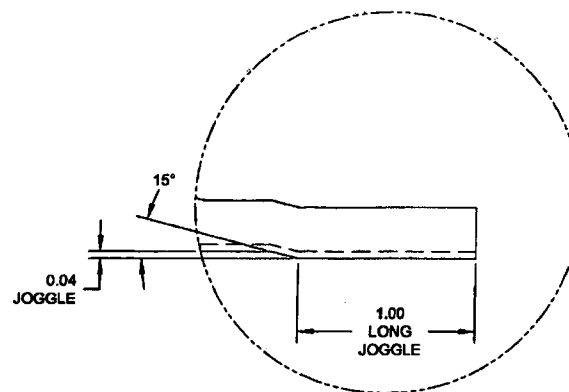
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REF DART SPEC M304S20GA
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-39 = 0.88 lbs; D4956-41 = 0.68 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2014-04-17

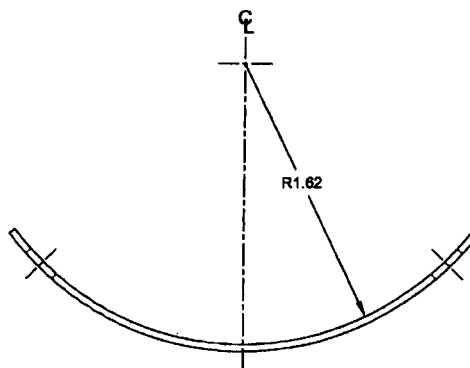
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CHECKED		DRAWING NO.	REV. A
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DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C2-4
C8-5 C2-5
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B6-4
B7-5 B3-5
B7-6 B3-6
B7-7 B3-7

RELEASED
2014-04-17
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N</i>	D4956	SHEET 8 OF 8
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